Work Ord Wednesday, Oc				*125	5458*							Page 1
Item ID: Revision ID:	D3492-041		F	Accept	*N900	040	100)* ፡	Setup	Start	*N	S1*
Item Name:	Plug Assembly	1								Stop	*NI	S2*
Start Date:	10/8/2014	Start Qty: 16.00	*16*		Cust Item 1	D:					1 14	17
Required Date Reference:	: 10/8/2014	Req'd Qty: 16.00	*16*		Customer:							
Approvals:	Process Pla	n: _MC	Date: 14-10-08	Tooling:	D	ate:		I	Run	Start	~1/	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	ID .	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3492	·#	ELL										
200		7		0.00						,		, 1
200				0.00				XIG		4_	Jll_	14/0.00
Small Fab Small Fab		Memo assemble as	per dwg	0.00				·				
210		QC5- Inspect part comp	leteness to step on W/O	0.00								DAS
210				0.00				16)_			38 /4-/C
Quality Control		Memo		0.00								0 00 1 7
220	·	Identify as per dwg & Se	tock Location: 62	0.00								e August a
220			, 1	0.00			1	b		- 0041	DAS	
Packaging		Memo		0.00				00	T 0 7	2014	06 3-89	

Packaging

DQA:			Date:										¥	A D'T
						WORK ORDER NON	-CC	ONFO	RMANCE / L					AEROSPACE
QA Closed:			Date:							<u> </u>	Nork Order ι	pdate only		
Work Orde	er:					DISPOSITION				AGAINST [DEPARTMEN	r/PROCESS		
	-				_	Rework			Skid-tube	Crosstube		Water Jet	\neg	Engineering
Part N	١o.					Scrap		į	Machining	Small Fab	Pr	od. Eng. Coor.	╗	Quality
	-					Use-as-is			noforming	Finishing		ore/Packaging	_	Other
NCR N	۱o.					Suspected Unapproved]		Large Fab	Composite		Supplier	_	
Root					Desci	ription of work order update		Initial	Ac	ction	Sign &		Т	, , , , , , , , , , , , , , , , , , ,
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	n	QC Inspector
Design													\exists	
Doc/Data												ļ		
Equip/Tooling												-		
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process ,														
Supplier										•			ł	:
Training														
Transport							}							
Unapproved														
							FAI	ULT CAT	regory					
Landi	ng G	Bear				General		•		_				
		Bending				Bend		Folio/P	rogram		Outside Dir	nensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Unde	r tolerance		Set-up
	Ш	Cracks				Broken/Damage/Defect		Hardwa	re	L	Part Incorre	ect	┙	Temperature/Cure
		Crimp/Kir	k/Ripple	/Wave	<u> </u>	Burrs		4	ion Incomplete/U		Part Lost/N	lissing	<u>ا</u>	Weld
		Cuffs				Contamination		Instruct	ions Incomplete,	/Unclear	Part Moved	l [Wrong Stock Pulled
	Ш	Crushing				Countersink		Misalig	ned/off center	· [Positioned	Wrong		
		Heat Trea	t			Cut Too Short		Mislabe	eled		Power Loss	/Surge [\Box (Other
		Inspection	n Strip in	Tube	· L	Drawing		Misread	d					
	Date Step Qty Inta Tooling Ing/Pre Ing					Drill Holes		Off-set						
	Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence					Finish		Out of 0	Calibration					
	Cause Date Step Qty ign i/Data ip/Tooling idling/Pre terial erator set/Setup cess plier ining insport approved Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence					Fit/Function	1	Out of 9	Sequence					

Work Order ID 125458 *125458* Page 2 Wednesday, October 08, 2014 9:00:59 AM D3492-041 Item ID: Accept Setup Start *N900040100* **Revision ID:** Stop **Item Name:** Plug Assembly *16* **Start Date: Start Qty:** 16.00 10/8/2014 **Cust Item ID: Required Date: 10/8/2014** Req'd Qty: 16.00 *16* **Customer:** Reference: Run Start **Approvals:** Date: _____ Tooling: Date: Stop QC: Date:_____ SPC (Y/N): Date: *NR2* Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Reject Reject Accept Insp. **Work Center ID Description** Qty Qty Number Stamp **Run Hours** Code 230 QC21- Final Inspection - Work Order Release 0.00 *230* MUS 14-10-08

MF 10-08

0.00

Memo

OC

Quality Control

DQA:			Date:										TAD	
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF	PDATE			AEROSPA	C E
QA Closed:			Date:							W	ork Order up	odate only		
Work Orde	er:					DISPOSITION				AGAINST DI	PARTMENT,	/PROCESS		
						Rework]		Skid-tube	Crosstube	7	Water Jet	Engineering	٦l
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	1
						Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other	1
NCR N	No					Suspected Unapproved			Large Fab	Composite]	Supplier]
Root					Descr	ription of work order update	1	nitial	Acti	ion	Sign &			
Cause	(Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspecto	r
Design														•
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material										•				
Operator														
Offset/Setup														
Process	\Box													
Supplier														,
Training	Щ													
Transport														
Unapproved	<u> </u>						l							
							FAI	ULT CAT	FEGORY					
Landi					_	General		1		_	_	г		
	-	-				Bend	_	1	Program		Outside Dim	į-	Pressure/Forced	
	\vdash		t Concer	ntric	_	BOM/Route	L	Grain		<u> </u>	Over/Under	-	Set-up	
	⊢					Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>	Part Incorred	-	Temperature/Cur	e
	_		k/Ripple	/Wave		Burrs	<u> </u>	1	ion Incomplete/Un	· —	Part Lost/Mi	· ·	Weld	
					-	Contamination	<u> </u>	1	tions Incomplete/U	Inclear	Part Moved	L	Wrong Stock Pull	ed
		-			_	Countersink	_	1 ~	gned/off center		Positioned V			
	⊢				-	Cut Too Short	<u> </u>	Mislabe		L	Power Loss/	Surge [Other	
:	_			Tube	ļ	Drawing	<u> </u>	Misread					··· •	
	\vdash					Drill Holes	<u> </u>	Off-set						
	ing/Pre crial cria				<u> </u>	Finish	<u></u>	1	Calibration					
	L IW	ave/Twi	st in Tub	e		Fit/Function	L	Out of S	Sequence					

Work Order ID: 125458

125458

Parent Item:

D3492-041

D3492-041

Parent Item Name: Plug Assembly

Start Date: 10/8/2014

Required Date: 10/8/2014

Start Qty: 16.00

Required Qty: 16.00

Comments:

·IPP rev A 06.03.03 New Issue

EC IPP Rev:B 06-08-28 As per Rev B JLM

IPP Rev:C 07-12-06 Rev C dwg DD verified by:EC

	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1		Manufactured	No				Each	193.0000		16			
D3492-1									**	<u>ell</u>		11/10/	0 E
				Location	:	Loc C	<u>Oty</u>	Loc Code					
				FP001			193						
					111578		2						
					114879		7						
					119646		2						
					120519		2						
					122460		60	,		XIL			
					124026		120			,, (
NAS1611-010		Purchased	No				Each	335.0000		16	0.0		1
NAS1611-	-010								**		Ill	,	4/10

O-RING

Location Loc Qty Loc Code FP001 335 m126988 3 m127813 4 m128375 10 m129198 44 m129405 82 m129523 192

DQA:			Date:											ng.	DART
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / U		Norl	< Order up	odate only		AEROSPACE
Work Orde	·r·		•		·	DISPOSITION				AGAINST D		· · · · · · · · · · · · · · · · · · ·		<u> </u>	
Part N NCR N	- !o					Rework Scrap Use-as-is Suspected Unapproved		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Desc	ription of work order update		nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved		•													
							FA	ULT CAT	EGORY						
Landir		ear Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch	nk/Ripple at n Strip in natter	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misreac Off-set	on Incomplete/U ions Incomplete/ ned/off center led	'Unclear	O P:	utside Dime ver/Under art Incorrect art Lost/Mit art Moved ositioned Wower Loss/S	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tw		e		Fit/Function		i	Sequence		_				

Out of Sequence

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

-NAS1611 O-RING (SEE TABLE) D3492-XX PLUG (SEE TABLE)-

D3492-XXX PLUG PARTS LIST

		OT AILTO LIGI								
	DESCRIPTION	PART NUMBER	QTY -055	QTY -053	QTY -051	QTY -049	QTY -047	QTY -045	QTY -043	QTY -041
\neg	PLUG ASSEMBLY	D3492-041								X
	PLUG ASSEMBLY	D3492-043			, i				Х	
7	PLUG ASSEMBLY	D3492-045						Х		
\neg	PLUG ASSEMBLY	D3492-047					Х			
	PLUG ASSEMBLY	D3492-049				Х				
\neg	PLUG ASSEMBLY	D3492-051			X					
Π.	PLUG ASSEMBLY	D3492-053		Х						
	PLUG ASSEMBLY	D3492-055	Х							
_	PLUG	D3492-1								1
	PLUG	D3492-3							1	<u> </u>
\neg	PLUG	D3492-5						1		
	PLUG	D3492-7					1			
7	PLUG	D3492-9				1				
\neg	PLUG	D3492-11			1					
	PLUG	D3492-13		1						
	PLUG	D3492-15	1							
-	O-RING	NAS1611-005						1		
\neg	O-RING	NAS1611-007					1			
\neg	O-RING	NAS1611-010			-					1
\neg	O-RING	NAS1611-012		1						
	O-RING	NAS1611-013							1	
\neg	O-RING	NAS1611-015	1		1					
	O-RING	NAS1611-016				1				

NOTES: 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

D

С

E	ADD -05	5 PLUG ASSY	& -15 PLUG	AP	13.08.08						
D	INCORP WAS 0.0	ORATED DEO	D3492-C-1. SHT 2 DIM C FOR -1	AJS	11.05.24						
С	ADD -04	9/-051/-053, CI	HANGE DRAWING FORMAT	PH	07.10.05						
В	ADD -04	7; UPDATE DI	M A FOR -045	PH	06.05.11						
Α	NEW IS	SUE		PH	06.01.04						
REV.	DESCRI	DESCRIPTION BY DATE									
DESIG	N	PH	DART AERO	SPACE L	TD						
DRAW	N	AP	HAWKESBURY, ON	ITARIO, CANA	DA						
CHECK	ŒD	#35	DRAWING NO.		REV. E						
MFG. A	PPR.	177	D3492		SHEET 1 OF 2						
APPRO	VED	149	TITLE	TITLE							
DE API	PR.	-#	PLUG								
DATE	13.0	8.08	COPYRIGHT © 2007 BY THE COCUMENT IS PRIVATE AND CONFIDENTIAL AND IN HOT TO BE USED FOR MAY PURPOSE OR COPIED OR	S BUPPLED ON THE EXPRES	IS CONDITION THAT IT IS						

DQA:			Date:										DAR [†]
QA Closed:			Date:			WORK ORDER NON	I-C(ONFO	RMANCE / L		ork Order up	odate only	AEROSPACE
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	-	-				Rework Scrap Use-as-is Suspected Unapproved		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	╡	Water Jet d. Eng. Coor. re/Packaging Supplier	
Root					Desc	ription of work order update		Initial	А	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Des	cription	Date	Verification	n QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
							FA	ULT CA1	ΓEGORY	· · · ·			
Landi		Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea	nk/Ripple			General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short		Grain Hardwa Inspect Instruct	ion Incomplete/i ions Incomplete gned/off center	·/Unclear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	\vdash	Inspectio		Tube	-	Drawing	\vdash	Misread			Trower ross/	onike	Tottlet
	\vdash	Marks/Ch		rube		Drill Holes	\vdash	Off-set		•			
	$\vdash \vdash$	Turning S			-	Finish	-	-	Calibration				
		Wave/Tw			-	Fit/Function	-	4	Sequence				